

Date: Tuesday, 11/29/2005 3:06:17 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number : 25019	
Estimate Number : 10534	
P.O. Number : N/A	Part Number : D2574
This Issue : 11/29/2005 S.O. No. : N/A	Drawing Number : D2574 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 24840	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 1/5/2006 Qty: 8 Um: Each
Checked & Approved By : SEE ABOVE DATE & USER	
Comment : Est: H 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2574KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2574

Ensure that grain is along 5.00" length

Batch No: B21817A (1)

B25204

J.G. 06/01/16

8

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 25019 Double check by: SD

J.G. 06/01/16
 MS 06/01/18

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges. N/A

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

-MS 06/01/18
 -J.G.

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 06/02/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/29/2005 3:06:17 PM
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Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

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Seq. #:	Machine Or Operation:	Description :
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4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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-M8 06/01/18
-J.G.



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

86

06-01-24

8

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FF 06-02-09

8

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/02/19

8

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

C206102120

(8)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51480

C206102120

(8)

10.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/02/21

(8)

DD 06/02/21

(8)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

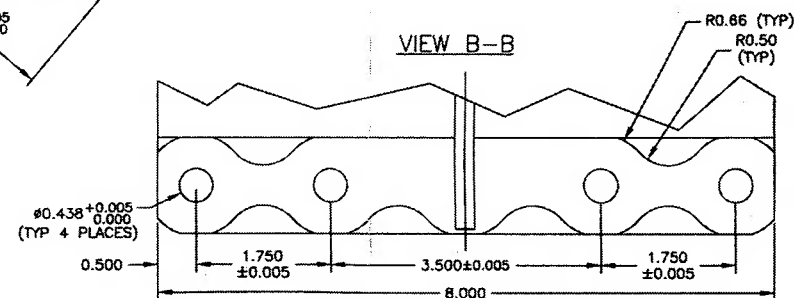
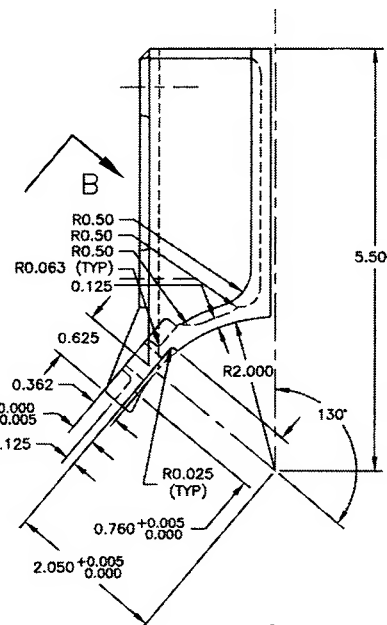
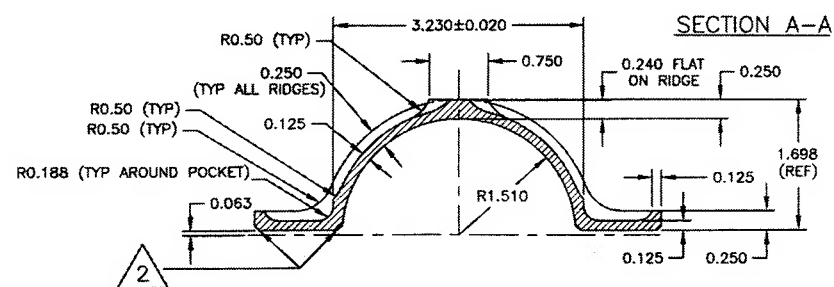
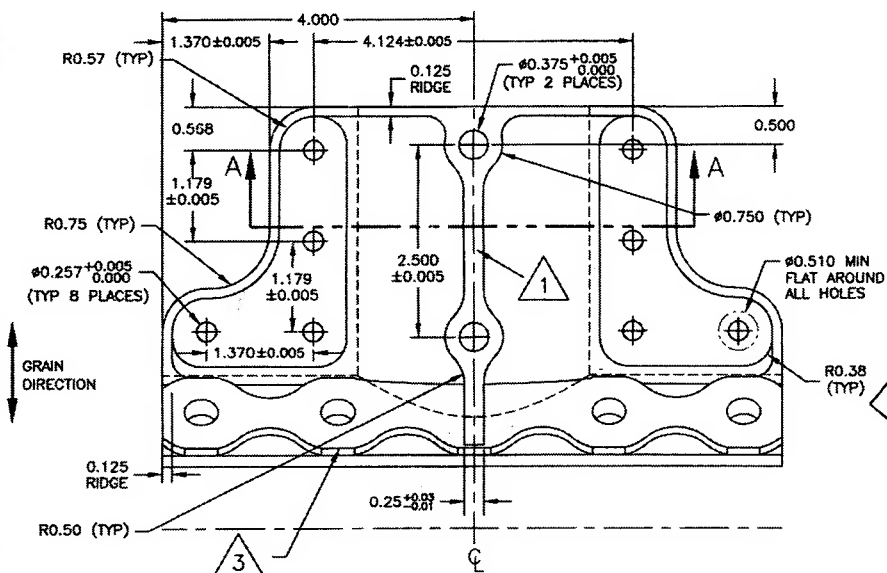
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
02-09-25



NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND

D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR.; 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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DART AEROSPACE LTD.

DESIGN
CHECKED
DATE
02.09.06

DRAWN BY
APPROVED
TITLE
INNER AFT SADDLE

DART DART AEROSPACE LTD.
WARRICK, ONTARIO, CANADA
DRAWING NO.
D2574
REV. D
SHEET 1 OF 1
SCALE
2:3

DART AEROSPACE LTD		Work Order: 25019
Description: Saddle, Aft Inboard		Part Number: D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.750	1.750	1.750	1.747		
C	3.495	3.505		3.500	3.500	3.500	3.497		
D	1.745	1.755		1.750	1.750	1.750	1.748		
E	7.990	8.010		8.002	8.003	8.004	8.004		
F	0.490	0.510		.505	.503	.506	0.500		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		.502	.504	.505	0.499		
J	1.174	1.184		1.180	1.180	1.180	1.179		
K	0.558	0.578		.571	.574	.574	0.569		
L	1.174	1.184		1.180	1.180	1.180	1.179		
M	1.365	1.375		1.370	1.370	1.369	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.497		
O	4.119	4.129		4.121	4.124	4.124	4.120		
P	0.115	0.135		.126	.125	.127	0.128		
Q	0.115	0.135		.135	.135	.135	0.135		
R	0.240	0.260		.250	.250	.250	0.251		
S	0.115	0.135		.126	.125	.125	0.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.232	3.234	3.232	3.231		
V	0.230	0.250		.243	.241	.240	0.241		
W	0.115	0.135		.125	.125	.125	0.125		
X	0.307	0.312		.308	.311	.311	.309		
Y	0.760	0.765		.762	.762	.762	.762		
Z	0.352	0.372		.365	.360	.362	0.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.629	.629	0.623		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.248	.246	0.247		
AE	1.500	1.520		1.511	1.511	1.511	1.511		
AF	0.115	0.135		.135	.135	.135	0.135		
AG	0.240	0.280		.272	.270	.270	0.271		
AH	0.240	0.260		.252	.248	.250	0.249		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		.03	.03	.03	.03		
Accept/Reject									

Measured by:	M8
Date:	06/01/18

Audited by:	J.G
Date:	06/01/18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED
05.12.05

DART AEROSPACE LTD	Work Order: 25019
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

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				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.441	✓	✓	✓		
B	1.745	1.755		1.748	1.750	1.750	1.750		
C	3.495	3.505		3.497	3.501	3.500	3.500		
D	1.745	1.755		1.747	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.003	8.004	8.003		
F	0.490	0.510		0.500	.499	.499	.502		
G	0.257	0.262	DT8683	0.260	✓	✓	✓		
H	0.375	0.380	DT8684	0.377	✓	✓	✓		
I	0.490	0.510		0.4985	.501	.501	.500		
J	1.174	1.184		1.178	1.180	1.180	1.180		
K	0.558	0.578		0.570	.568	.572	.575		
L	1.174	1.184		1.176	1.180	1.180	1.180		
M	1.365	1.375		1.360	1.370	1.370	1.370		
N	2.495	2.505		2.497	2.501	2.500	2.500		
O	4.119	4.129		4.119	4.121	4.122	4.123		
P	0.115	0.135		0.128	.125	.125	.126		
Q	0.115	0.135		0.134	.135	.135	.135		
R	0.240	0.260		0.250	.247	.250	.250		
S	0.115	0.135		0.124	.125	.123	.123		
T	0.178	0.198		0.188	.188	.188	.188		
U	3.210	3.250		3.230	3.231	3.231	3.231		
V	0.230	0.250		0.234	.240	.240	.240		
W	0.115	0.135		0.122	.125	.125	.125		
X	0.307	0.312		0.312	.310	.310	.310		
Y	0.760	0.765		0.760	.762	.762	.762		
Z	0.352	0.372		0.356	.356	.359	.356		
AA	0.470	0.530		0.500	.500	.500	.500		
AB	0.615	0.635		0.622	.626	.623	.621		
AC	0.053	0.073		0.063	.063	.063	.063		
AD	0.240	0.260		0.246	.248	.246	.247		
AE	1.500	1.520		1.510	1.511	1.511	1.511		
AF	0.115	0.135		0.130	.135	.135	.135		
AG	0.240	0.280		0.265	.269	.270	.270		
AH	0.240	0.260		0.246	.251	.251	.251		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.033	.03	.03	.03		
Accept/Reject									

Measured by:	/ms
Date:	06/01/21

Audited by:	J.G.
Date:	06/01/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
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05.12.05